Work Order ID 116541

116541

April-17-14 7:56:32 AM

Item ID: D4871-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: End Fitting, Eye

Start Date: 4/17/14 **Start Qty:** 8.00 *8*

Required Date: 5/02/14 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 14-04-17 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4871	**Revision Nbr** Rev A								
100		0.00							
100									
Outsource5	**Memo**	0.00							
Outsource process - Machining	ISSUE P/O: 23860 POSSIBLE SUPPLIER:ATG C OF C IS REQUIRED								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	**Memo**	0.00							
Quality Control									
150		0.00							
150	PURCHASING								
Purchasing	**Memo**	0.00							
Purchasing	Issue P/O: 23860 LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required								

DAS 27 9-39 14/6/9

CL 14/04/17 8

8

CL 14/05/09

done @ ATG

N/A

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 116541

116541

April-17-14 7:56:32 AM

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	**Memo**	0.00							
Packaging	Ensure certificate of conformity is attached								
	identify : ST124					8X	DAS 28 9-89		JUN 09 2014
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	**Memo**	0.00							
Quality Control									

MCJ 14-06-10

MF 6-6-10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
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Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

April-17-14 7:56:35 AM

Work Order ID: 116541 *116541*

Parent Item: D4871-3 *D4871-3*

Parent Item Name: End Fitting, Eye

Start Date: 4/17/14 **Required Date:** 5/02/14

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP REV:A NEW ISSUE 14-01-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4871-3P		Purchased	No				Each	0.0000		8			
D4871-3P									**		4/16/14	(8)	
End Fitting													
M174PH-H900R1.000		Purchased	No				f	145.0000		3			
M174PH-H900R1.000									**		04/14/17		
17-4SS H900 ROUND BAR 1.00													

Location		Loc Qty	Loc Code
MAT031		145	
	m126952	37	
	m127334	60	
	m128314	48	

3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Doc/Data	☐									
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Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

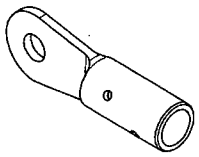
FAULT CATEGORY

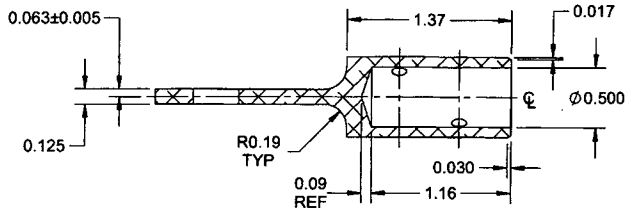
Landing Gear

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☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

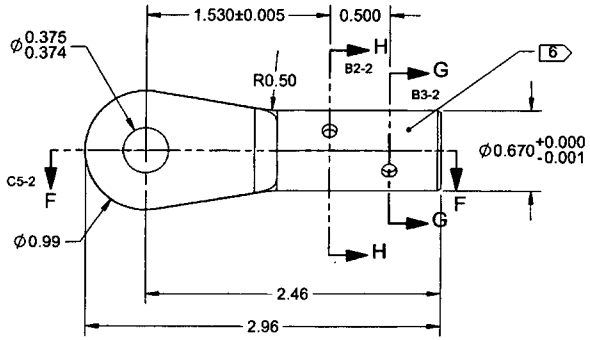
☐ Bend
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☐ Other

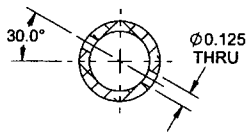




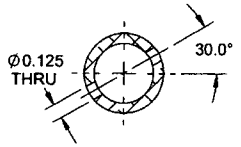
SECTION F-F B7-2

116541 MLJ
14-04-17





SECTION G-G C5-2



SECTION H-H C6-2

RELEASED
DEC 2013 -12- 12

D4871-3 END FITTING, EYE

NOTES:
1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.11 lbs
8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	HS	DRAWING NO. D4871 REV. A
MFG. APPR.	JLM	SHEET 2 OF 2
APPROVED	HS	TITLE END FITTING SCALE NTS
DE APPR.	DS	
DATE	13.12.09	

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DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- ☐ Rework
- ☐ Scrap
- ☐ Use-as-is
- ☐ Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

- ☐ Skid-tube
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- ☐ Supplier
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- ☐ Other
- ☐

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Doc/Data	☐									
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Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Hardware
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- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

DART AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23860

Purchase Order Date 4/17/2014
PO Print Date 4/22/2014

Order From : VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-446-4544

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA – (Free Carrier)

3	D4869-1P	End Fitting, Eye	5/19/2014 Yes 5/19/2014	FN	10.00 Each			$71.75	$717.50

MACHINE AS PER DWG D4869 REV. A
B116536
MATERIAL: 174PH-H900R1.000 M126952

Line Total: **$717.50**

4	D4869-3P	End Fitting, Eye	5/19/2014 Yes 5/19/2014	FN	4.00 Each			$71.75	$287.00

MACHINE AS PER DWG D4869 REV. A
B116537
MATERIAL: 174PH-H900R1.000 M126952

Line Total: **$287.00**

5	D4871-3P	End Fitting	5/19/2014 Yes 5/19/2014	FN	8.00 Each			$145.00	$1,160.00

MACHINE AS PER DWG D4871 REV. A
B116541
MATERIAL: 174PH-H900R1.000 M126952

Note:

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 908035 Date: 06-Jun-14

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Ship To

CHANTAL LAVOIE
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Terms	Ship Via

Quantity	Description
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.
8 ea	Part: D4871-3P Rev: A END FITTING Job: 16216 PO: PO23860 Line: 5
8 ea	Part: D4871-1P Rev: A END FITTING Job: 16220 PO: PO23860 Line: 9

DATE : 06 June 2014

CERTIFIED SIGNATURE: _____

RECEIVER SIGNATURE : _____

CERTIFICATE OF CONFORMANCE

A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT ARE IN CONFORMANCE WITH THE REQUIREMENTS, SPECIFICATIONS, AND DRAWINGS REFERENCED IN THE ABOVE PURCHASE ORDER.

I.S.O. 9001 : 2008 REGISTERED / MADE IN CANADA

First Article Inspection Report

ATG INDUSTRIES INC.
731 Industrielle St
Rockland, Ontario K4K 1T2
Ph: 613 446-4544

Customer:	Dart Aerospace	Date:	March 19th, 2014	502
Part Number:	D4871-3P	Revision:	A	
PO Number:	PO23860	Qty:	8	FAI No.

Item	Dimension	Measurement Inspected by: Rene Tougas, Q.C.	Remarks
1	.063±.005	.0645	Section F-F
2	1.37	1.370	
3	.017	.017	
4	Ø.500	.500	
5	.030	.030	
6	1.16	1.60	
7	.09 REF	.130 DRILL POINT	
8	R.19 TYP	✓	
9	.125	.129	
10	Ø.375/.374	.3745	
11	1.530±.005	1.5312	
12	R.50	✓	
13	.500	.5014	
14	Note 6	✓	
15	Ø.670+.000/-.001	.6698	
16	2.46	2.462	
17	2.96	2.961	
18	Ø.99	.990	
19	Ø.125 thru	Ø.1237	Section G-G
20	30º	✓	
21	30º	✓	Section H-H
22	Ø.125 thru	Ø.1245	
23	Material:	17-4SS H900 1.50" RD BAR	Supplied by Customer
24	Treatment:	Liquid Penetrant	PO#20140212

skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO21093	**Customer:** ATG Industries Inc	**Dept:** NDT YUL	**Reference:** 20140212
Descr:	**PN:**	**S/N:**	**Qty:** 1
Make:	**Model:**	**Reg:**	**A/C S/N:**
TSN: 0	**CSN:** 0	**TSO:** 0	

Task: UNSCHEDULED | **Sequence:** 1

Work Required:

CARRY OUT NDT ON 16 PARTS AS PER PO: 20140212

Action Taken:	Date:	Initial/Stamp:
LPI C/O AS PER ASTM E-1417M-13 NO CRACK FOUND PEN.(ZL-37 , B#10A070), CLEAN(SKC-S,B#09F21K),DEV.(SKD-S2,B#09L04K) EMU.(ZR-10B,B#10A074).	JUN 04 2014	DOT. APP 20 53-89

Description	*Location*	*P/N*	*Qty*	*Batch*	*S/N Off*	*S/N On*

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	**ACA/SCA Stamp** DOT. APP 20 53-89	Date: JUN 04 2014
Name: ERIK MELIKIAN		